



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2574
Job Sheet 177094



Part No: D2574

Job Qty: 10 ea

Part Name: Saddle, Aft, In



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/4/18

Job Tracking No:

Due Date: 5/18/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV F IPP Rev: I As Per RevE 06-01-27 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	5/18/18	5/18/18	0.00	0.00	Start Up Machining		SBL 18/06/04
100	CNC Vertical Machining	10 pcs	5/18/18	5/18/18	1.21	15.63	HAAS 1		SBL 18/06/05
110	Mill Conv	10 pcs	5/18/18	5/18/18	0.00	1.25	Mill Conv 1		SBL 18/06/05
120	QC	10 pcs	5/18/18	5/18/18	0.00	0.00	QC2		
130	QC	10 pcs	5/18/18	5/18/18	0.00	0.00	QC8		9-89 18/06/11
140	HandFinish	10 pcs	5/18/18	5/18/18	0.00	0.40	HandFinish1		SA 18-06-12
150	Powdercoat	10 pcs	5/18/18	5/18/18	0.00	0.33	Powdercoat1		9-89 6-13
160	QC	10 pcs	5/18/18	5/18/18	0.00	0.00	QC3		JUN 14 2018
170	Packaging	10 pcs	5/18/18	5/18/18	0.00	0.00	Packaging3		9-89 DAS
180	QC21-SA	10 Ea	5/18/18	5/18/18	0.00	0.00	QC21		JUN 14 2018 6

Part Op 100 - Program Batch No. 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Descriptions: Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

110 - Machine keyway as per dwg D2573 & D2574

150 - START TIME: 10:50 FINISH TIME: 11:20 O.U.T. 320° IN 134831

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	10 Ea (1 ea)	90-Start up Operation	

S069067 → S077014

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-005	10	39	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Aft Inboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Aft Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Aft Inboard	3.495Inches + 0.010 - 0.000	3.505 3.495		

Plex 5/4/18 3:05 PM Dart.Gagnon.Michelle



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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S077018



Part: D2574

Job No: 177094

Serial No/Batch: S077018

Revision: Rev.F

Inspector:

Exp Date: 06/01/2018

Instructions: D2574 Rev C, sheets 1-3 Date: 06/01/18

501

4	Saddle, Aft Inboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745
5	Saddle, Aft Inboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990
6	Saddle, Aft Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Aft Inboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Aft Inboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Aft Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Aft Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Aft Inboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Aft Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Aft Inboard	1.365Inches	+ 0.010 - 0.000	1.375 1.365
14	Saddle, Aft Inboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Aft Inboard	4.119Inches	+ 0.010 - 0.000	4.129 4.119
16	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Aft Inboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Aft Inboard	3.210Inches	+ 0.040 - 0.000	3.250 3.210
22	Saddle, Aft Inboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Aft Inboard	0.307Inches	+ 0.005 - 0.000	0.312 0.307
25	Saddle, Aft Inboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Aft Inboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Aft Inboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Aft Inboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Aft Inboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Aft Inboard	1.500Inches	+ 0.020 - 0.000	1.520 1.500
32	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Aft Inboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Aft Inboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Aft Inboard	0.023Inches	+ 0.020	0.043

5/4/20

[Dart Hawkesbury] Job Sheet - Gagnon-Donovan, Michelle

- 0.000

0.023

Plex 5/4/18 3:05 PM Dart.Gagnon.Michelle

DART AEROSPACE LTD	Work Order: 177 094
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.000	8.000	8.000		
F	0.490	0.510		0.500	0.502	0.500	0.499		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.499	0.499	0.500	0.497		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.567	0.5685	0.568	0.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.125	0.125	0.135	0.135		
Q	0.115	0.135		0.125	0.126	0.132	0.126		
R	0.240	0.260		0.250	0.253	0.250	0.252		
S	0.115	0.135		0.125	0.128	0.130	0.131		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.232	3.232	3.232	3.232		
V	0.230	0.250		0.232	0.232	0.232	0.232		
W	0.115	0.135		0.133	0.132	0.135	0.135		
X	0.307	0.312		0.310	0.311	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.364	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.621	0.621	0.622	0.624		
AC	0.053	0.073		0.065	0.065	0.065	0.064		
AD	0.240	0.260		0.250	0.250	0.250	0.2495		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.125	0.125	0.135	0.135		
AG	0.240	0.280		0.265	0.265	0.265	0.265		
AH	0.240	0.260		0.249	0.249	0.249	0.249		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: SBL
Date: 18/06/05

Audited by: [Signature]
Date: 18/06/11

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 177094
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	17	18		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.005		
F	0.490	0.510		0.500	0.500	0.500	0.500		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.500	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.128	0.133	0.133	0.133		
Q	0.115	0.135		0.127	0.127	0.127	0.126		
R	0.240	0.260		0.252	0.254	0.252	0.252		
S	0.115	0.135		0.128	0.126	0.127	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.236	0.237	0.236	0.236		
W	0.115	0.135		0.131	0.125	0.131	0.135		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.365	0.365	0.369		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.623	0.623	0.623		
AC	0.053	0.073		0.063	0.053	0.053	0.052		
AD	0.240	0.260		0.251	0.251	0.251	0.251		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.133	0.133	0.133	0.133		
AG	0.240	0.280		0.265	0.265	0.265	0.265		
AH	0.240	0.260		0.251	0.251	0.249	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: SBL	Audited by: [Signature]
Date: 18/10/11	Date: 18/10/11

Measured by: SBL	Audited by: [Signature]
Date: 18/10/11	Date: 18/10/11

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DART AEROSPACE LTD		Work Order: 177 094	
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Inspection Dwg: D2574 Rev. F		Page 1 of 1	

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B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.004	8.002				
F	0.490	0.510		.500	.500				
G	0.257	0.262		.257	.257				
H	0.375	0.380		.375	.375				
I	0.490	0.510		.500	.501				
J	1.174	1.184		1.174	1.174				
K	0.558	0.578		.568	.570				
L	1.174	1.184		1.174	1.174				
M	1.365	1.375		1.370	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.124	4.124				
P	0.115	0.135		.131	.132				
Q	0.115	0.135		.126	.127				
R	0.240	0.260		.252	.252				
S	0.115	0.135		.126	.128				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.230	3.230				
V	0.230	0.250		.236	.236				
W	0.115	0.135		.130	.130				
X	0.307	0.312		.311	.311				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.369	.369				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.623	.624				
AC	0.053	0.073		.053	.053				
AD	0.240	0.260		.250	.251				
AE	1.500	1.520		1.510	1.510				
AF	0.115	0.135		.126	.132				
AG	0.240	0.280		.265	.265				
AH	0.240	0.260		.251	.251				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by: <u>SB L</u>
Date: <u>18/06/05</u>

Audited by: <u>am</u>
Date: <u>18/06/11</u>

Rev	Date	Change	Revised by	Approved
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